

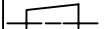

- 1.需打钢印
2. 需喷码
- 3.表面处理见第五页

钢印要求（上海电气）：

SWP CN 07214 18 01 001
A9B10193396
SWP: 西门子风电
CN: 中国 (零件运往何处)
07214: 飞跃代码
18: 生产年份 (根据实际生产年份)
01: 生产月份 (根据实际生产月份)
001: 序号从001-999
A9B10193396: 零部件物料号

字体高度10mm

Note1	All dimensions are in mm.
Note2	In case of conflict between requirements of 2d-drawing and any received reference 3d file or DXF file, then the requirements on the 2d-drawing shall prevail.
Note3	General tolerances: For unspecified measurements the tolerance classes listed below apply: The tolerances for linear dimensions: Tolerance class A acc. to ISO 13920:1996; The tolerances for angular dimensions: Tolerance class A acc. to ISO 13920:1996; Tolerances for straightness, flatness, and parallelism: Tolerance class E acc. to ISO 13920:1996.
Note4	Part with position no 2 and part with position no 3 can be processed as one part.

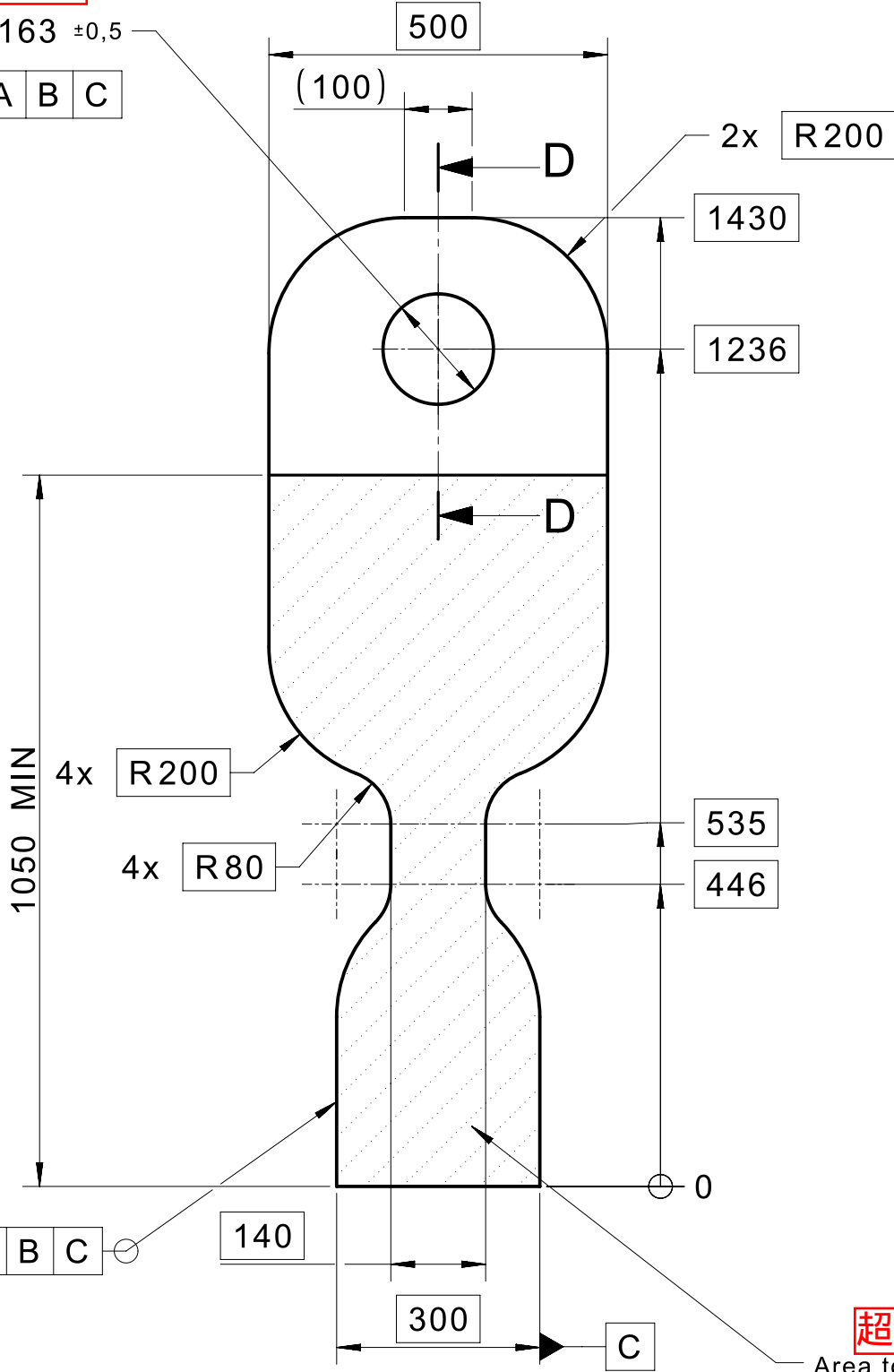
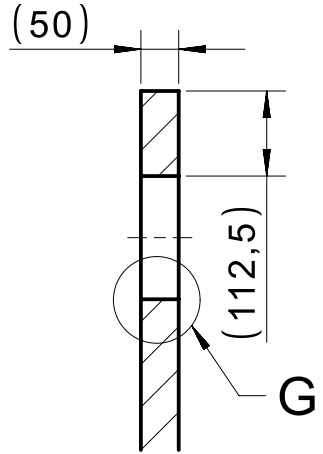
Pos	Qty	Dimension	Alt. Dim. 1	Alt. Dim. 2	Mat. req.	Purch. spec.		Mass
1	1	IPB 900-DIN 1025-2			S355J2 UT 1,2/2,4	Gr. 2.1 ZPS 1009554		1716,8kg
2	1	PI 150 mm.			S355NL UT S3/P	Gr. 2.2 ZPS 1009554		233,9kg
3	2	PI. 15 mm.			S355J2	Gr. 2.1 ZPS 1009554		9,7kg
Weight app.:		1932,6 kg	Proprietary class: Restricted				EC 3	
Part: Main beam, RESS					Draw, format: A1	ISO 	Draw, scale 1:20	Sheet no.: 1/5
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Siemens Wind Power A/S						D1359929		

Machined part POS 2 (1 : 10)

单件机加尺寸150
163为焊后机加尺寸

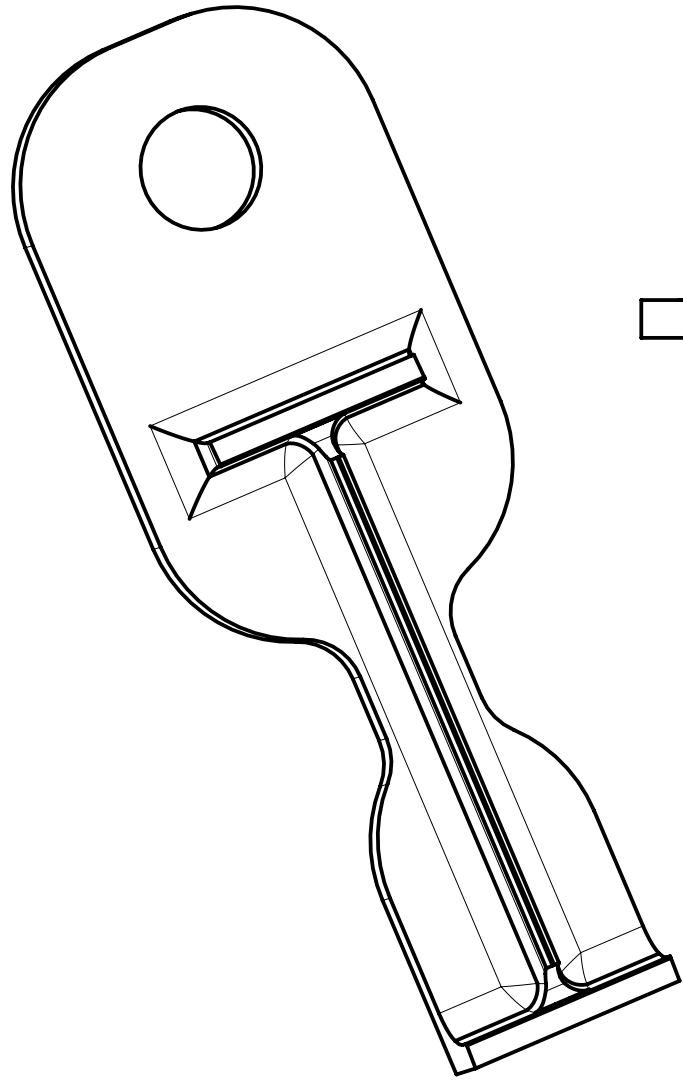
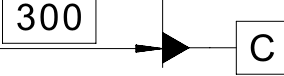
Ø 163 ±0,5
Ø 4 A B C

D-D (1:10)



5 A B C

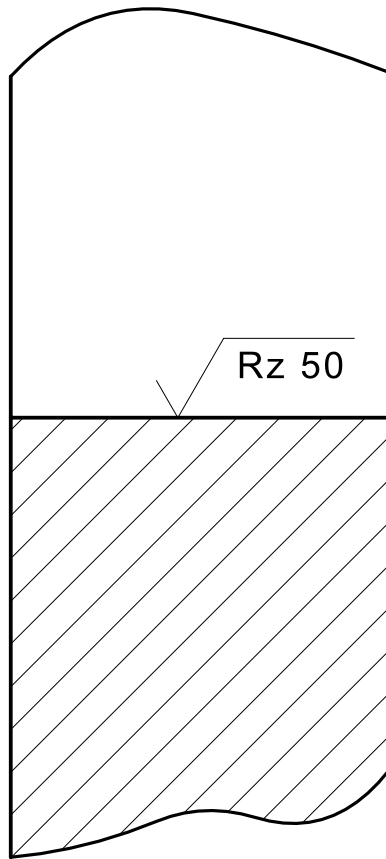
140



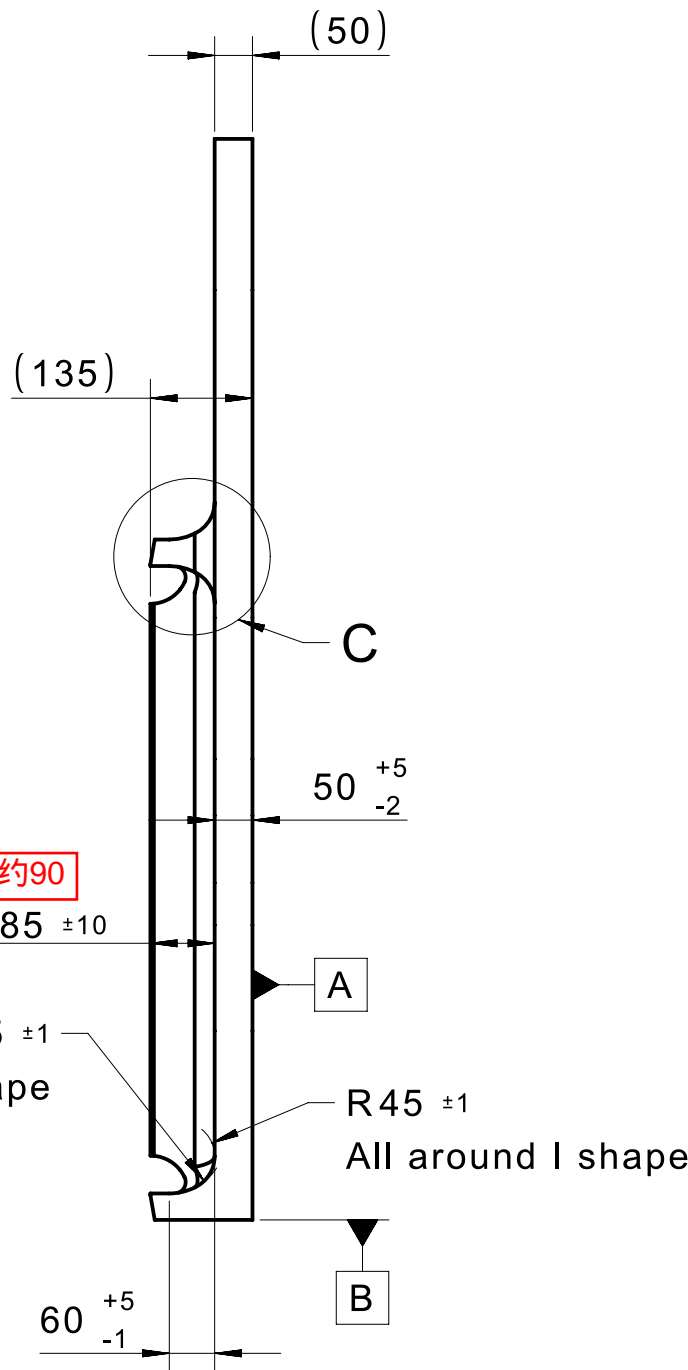
超声波检测的区域

Area to be ultrasonically tested.
(Acceptance level - See specified requirements for constituent product)

G (1:1)



剩余余量留背面，
焊后机加工



约90

85 ±10

R 75 ±1

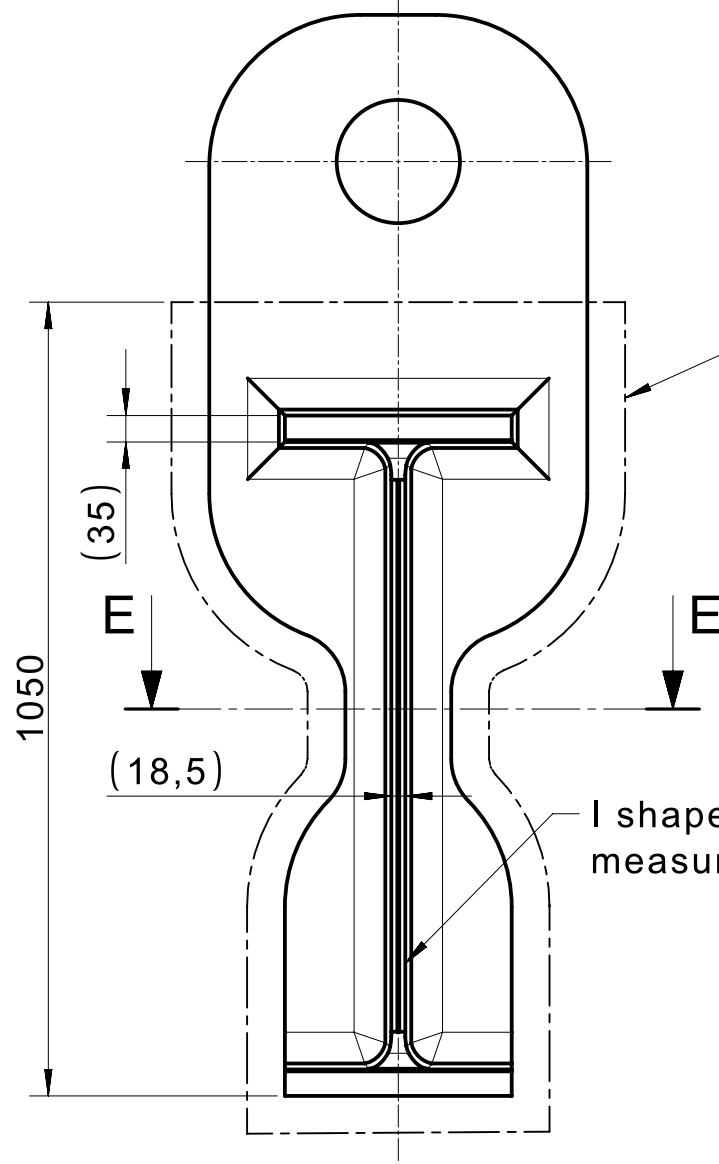
All around I shape

R 45 ±1

All around I shape

60 +5 -1

B

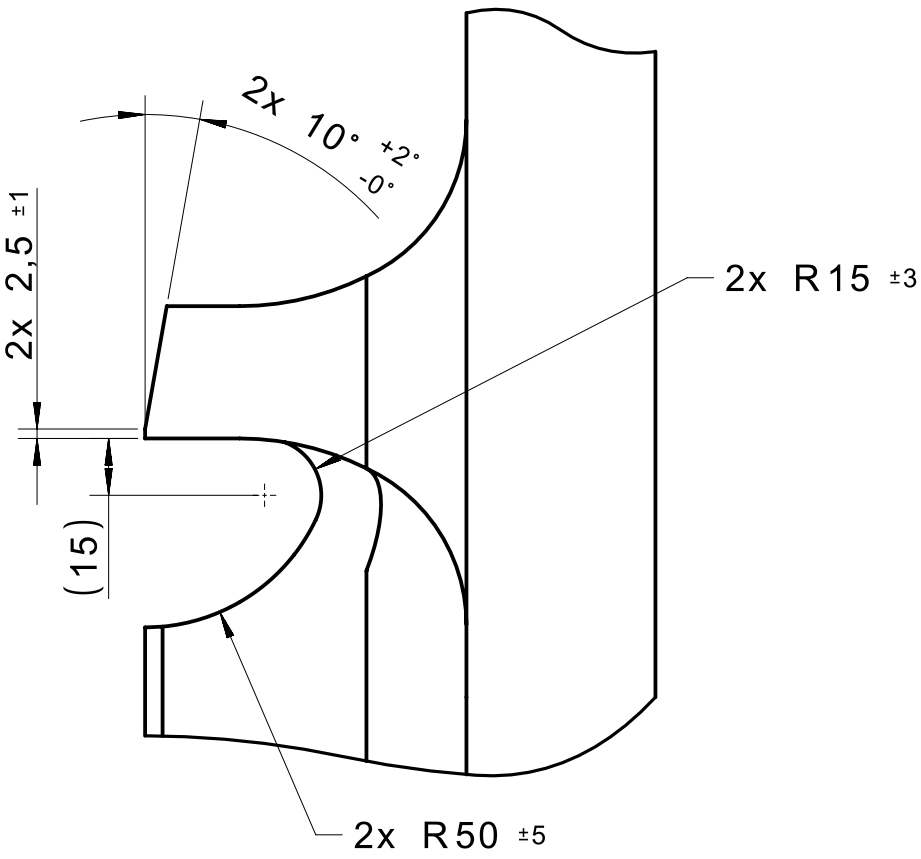


Area to be MT testet
after machining
LOT 7

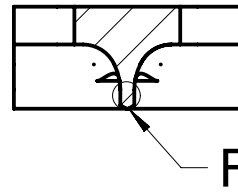
根据H900大梁截面形状加工

I shape on POS no. 2 shall be machined based on actual
measurement of each individual IPB 900 profile (POS 1).

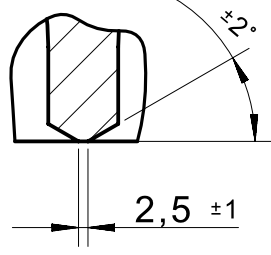
C (1:2)



E-E (1:10)



F (1:2)



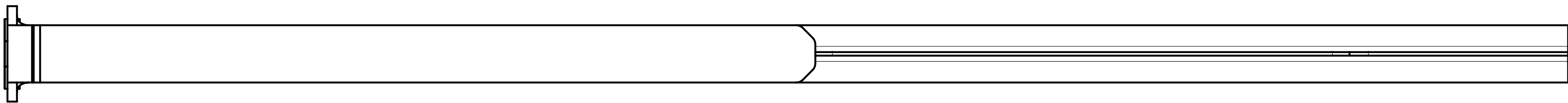
Additional technical requirements
Additional requirements regarding base-material, welding,
non destructive testing, surface treatment etc. see submitted
technical specifications given by the purchase order.

Overflader uden ruhedsangivelse: Bebejdet til Rz 50
Surfaces without spec. roughness: Machined to Rz 50

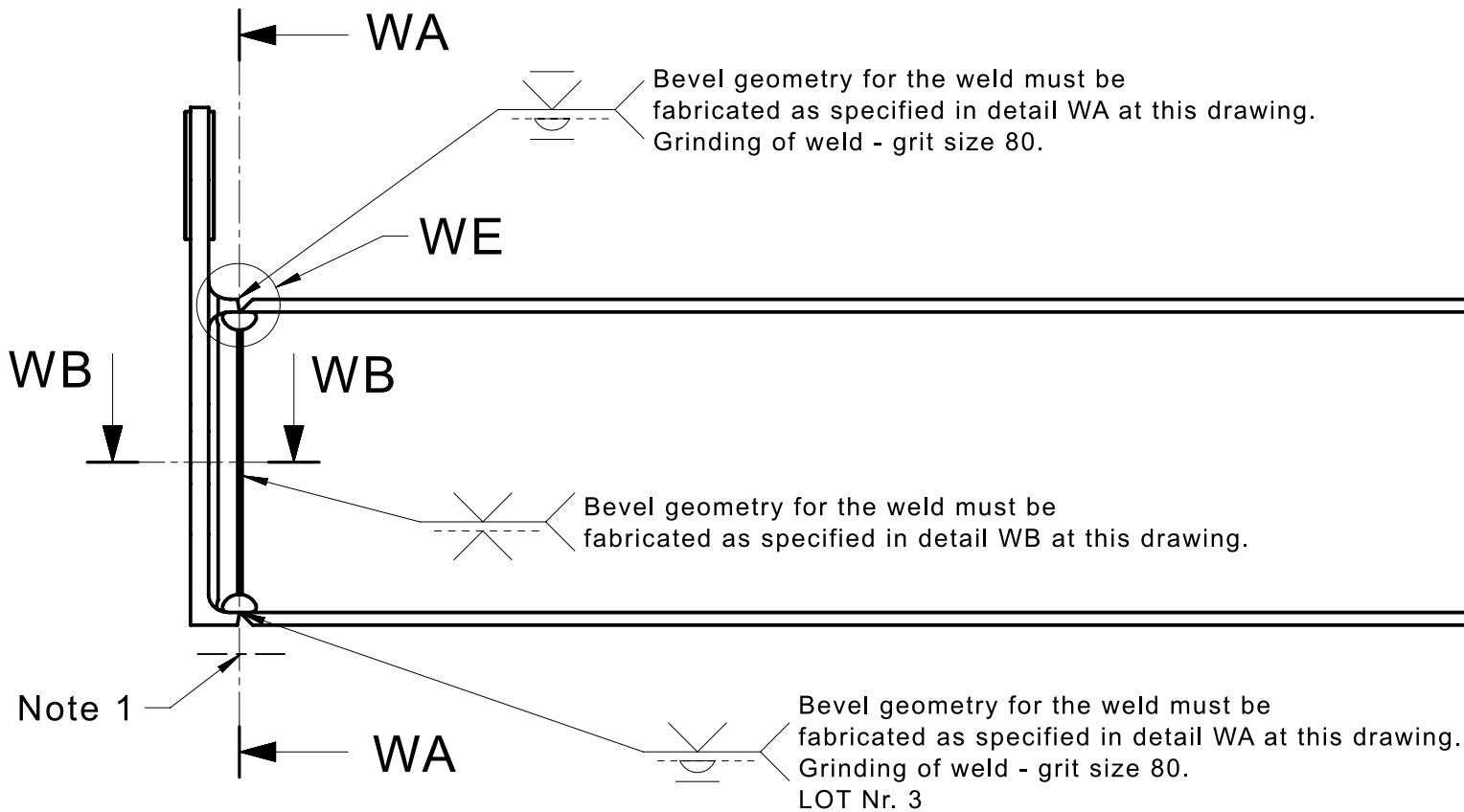
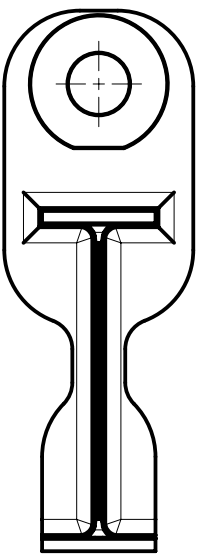
Weight app.:	1932,6 kg	Proprietary class: Restricted	EC 3
Part:	Main beam, RESS	Draw. format: A2	Sheet no.: 2/5
Draw. format:	ISO	Draw. scale: 1:20	Revision: 001
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SIEMENS D1359929			

Welding Assembly

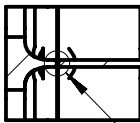
Note Q-1:Welding symbols according to ISO 2553:1992



WA-WA (1:20)



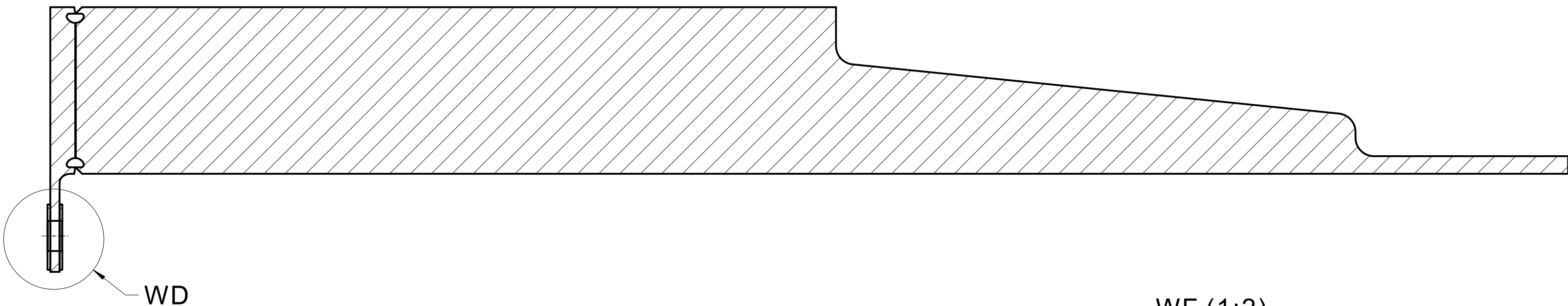
WB-WB (1:20)



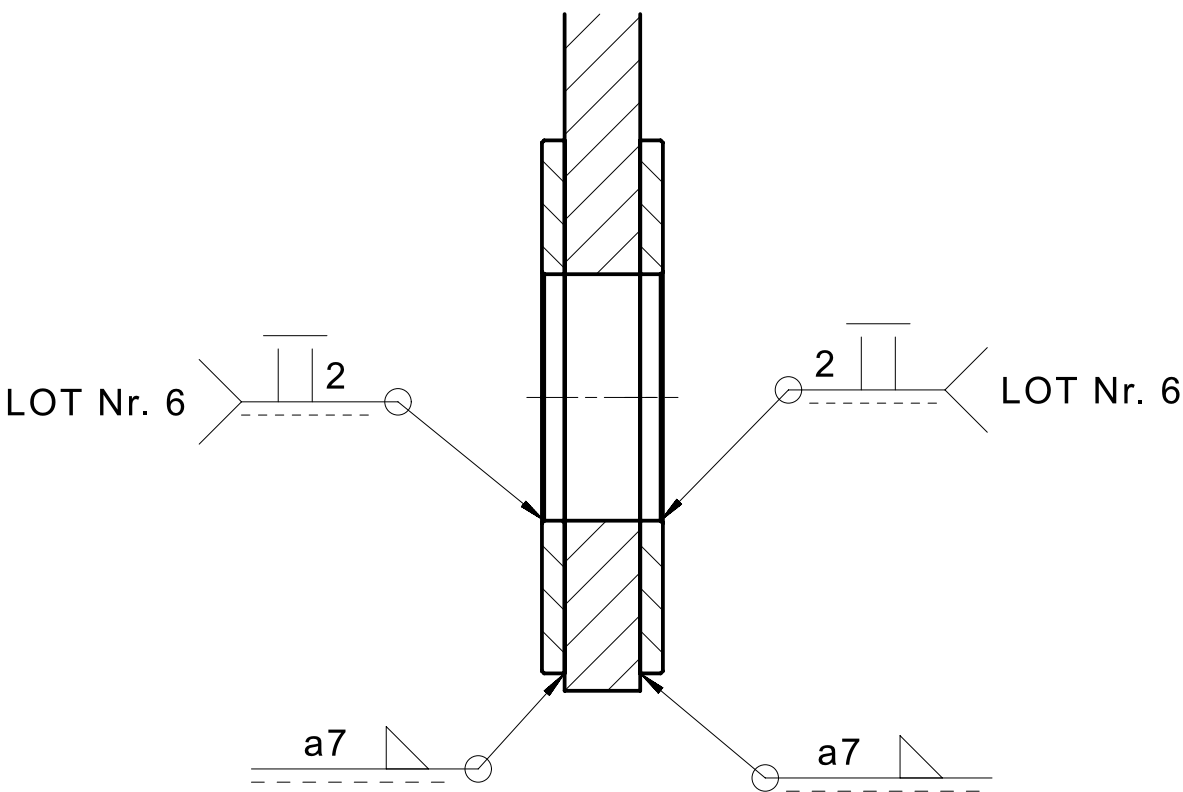
WC

WC

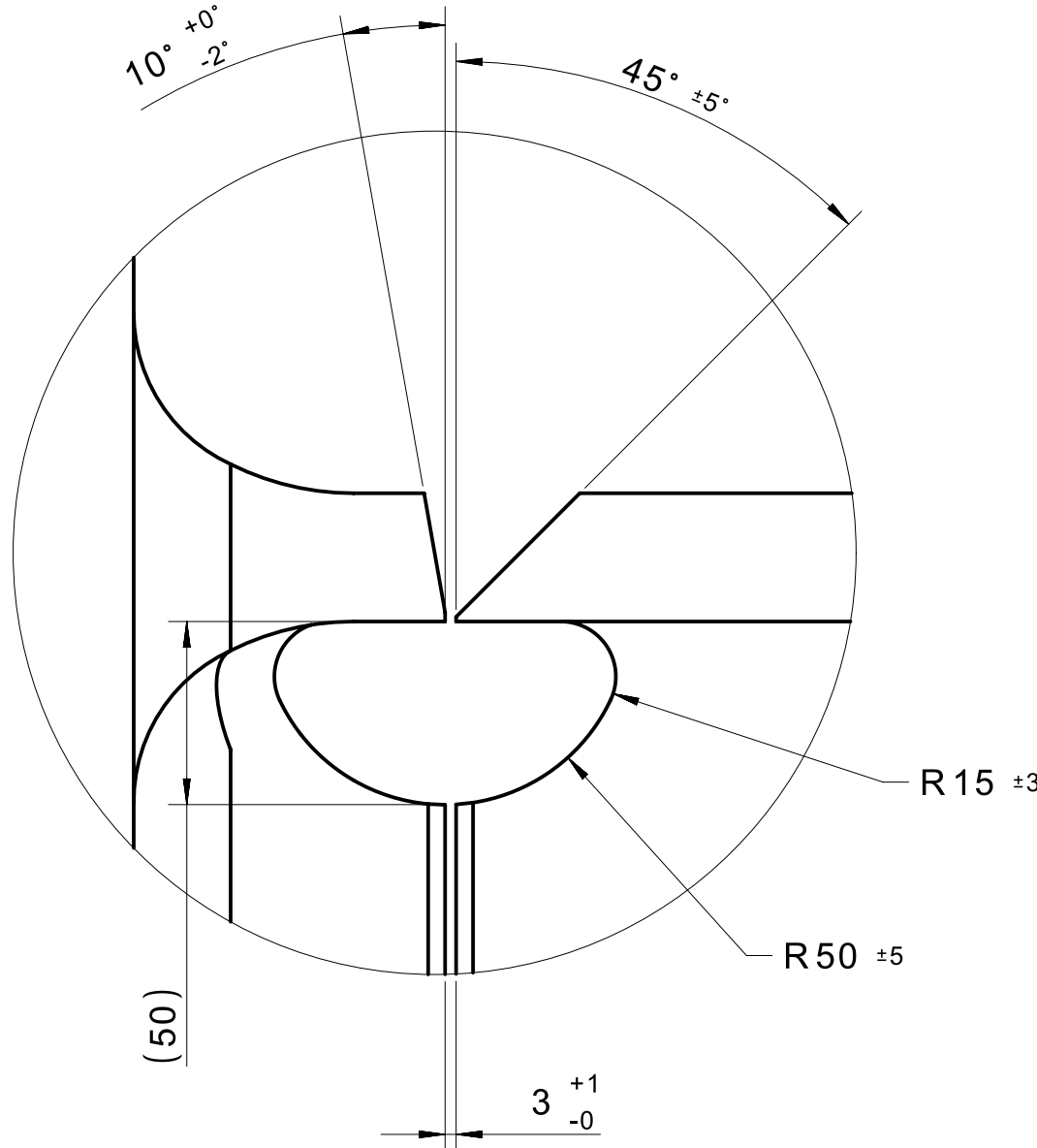
WC-WC (1:20)



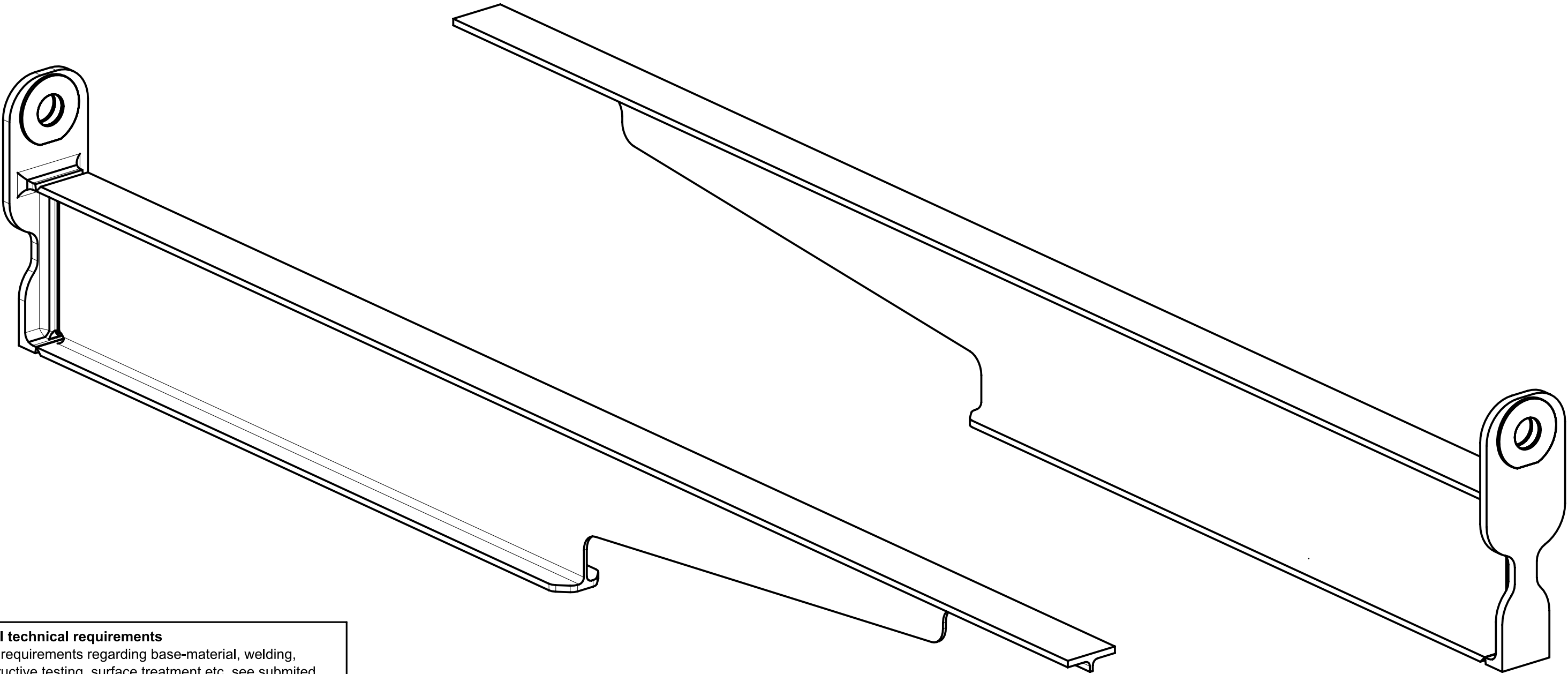
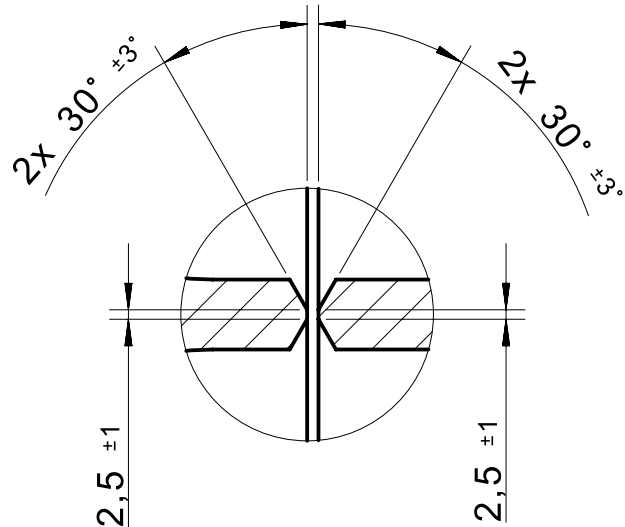
WD (1:5)



WE (1:2)



WF (1:2)



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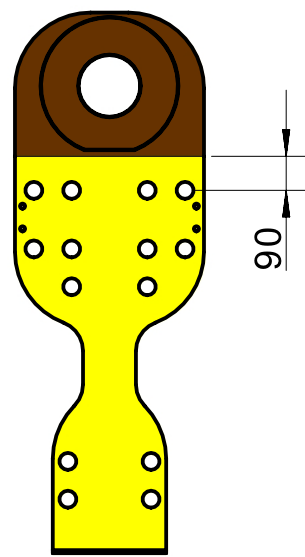
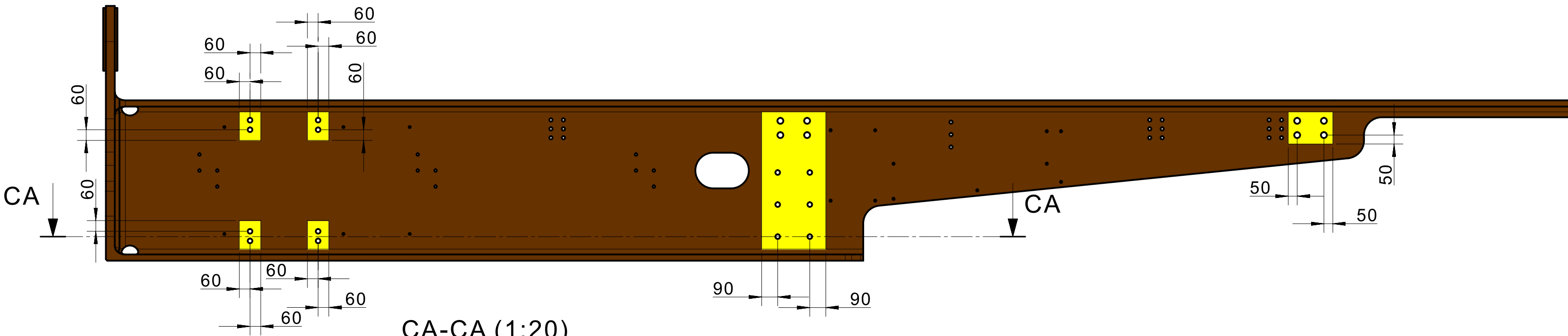
Note 1: Area to be machined after welding
Note 2: Before welding of the profile (POS 1) IBP 900-DIN 1025-2
to the machined end plate (POS 2) it must be ensured that
the end of the profile (POS 1) to be welded, has been tested
for internal soundness, according to the specification.

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SIEMENS		D1359929	

Surface corrosion protection system

Location of reference areas.

Color:	Used for:
<div></div>	M-1-1
<div></div>	M-1-2



通用要求：
1.清洁度Sa3
2.粗糙度85-130um
3.所有自由边倒角R2
M-1-1：法兰接触面。热喷锌，膜厚60-160um
M-1-2：C4要求。热喷锌，膜厚90um

喷码要求(上海电气)：

SWP CN 07214 18 01 001

SWP: 西门子风电

CN: 中国（零件运往何处）

07214: 飞跃代码

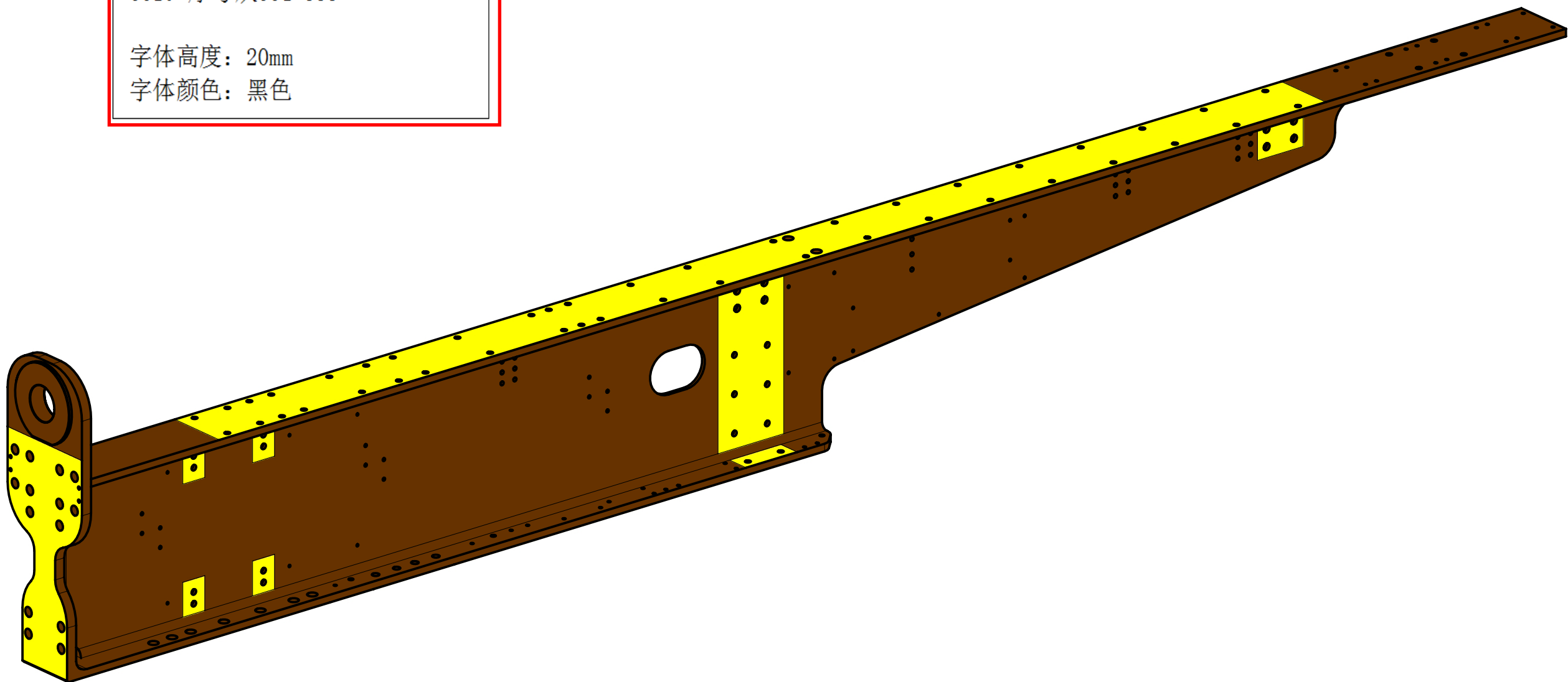
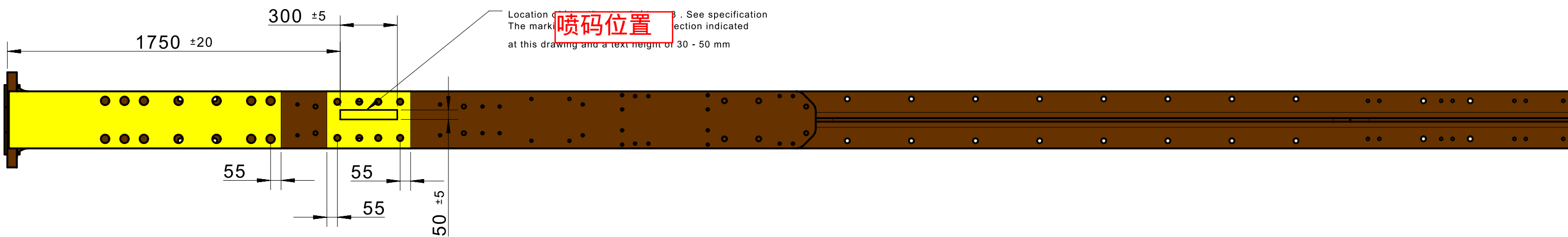
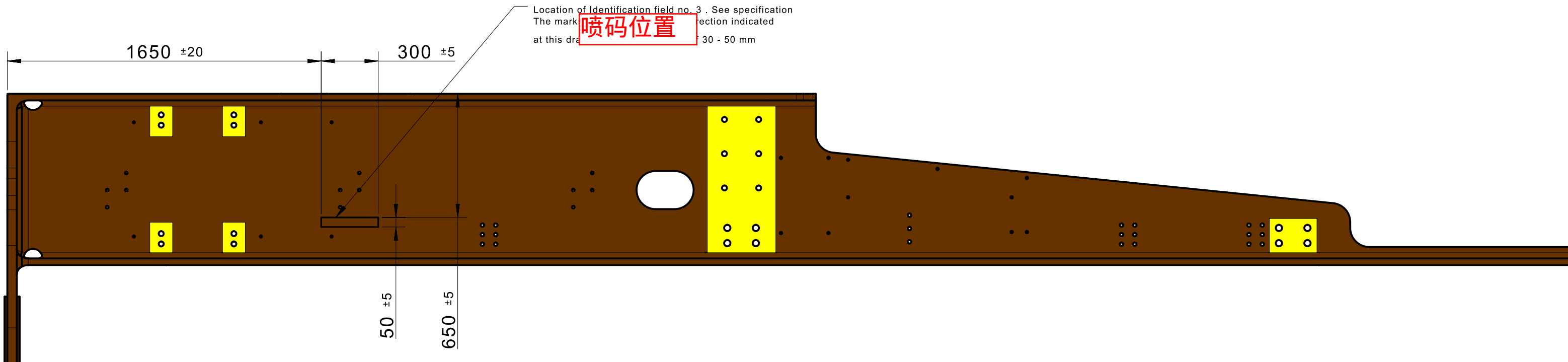
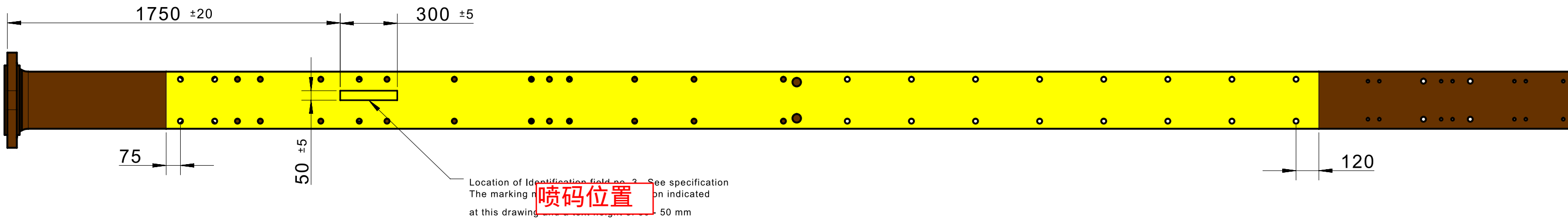
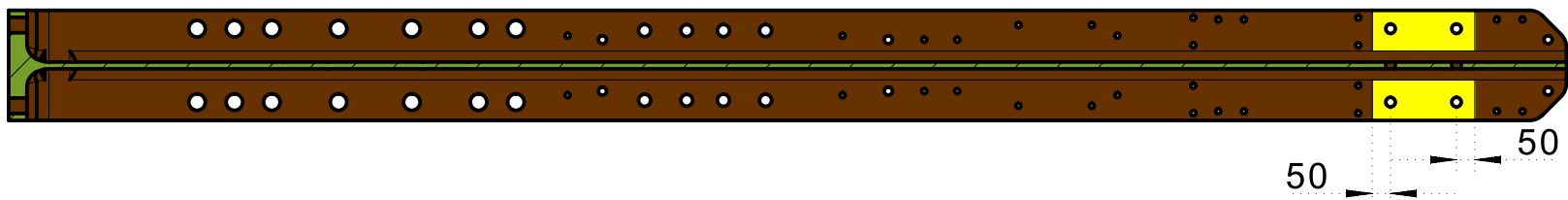
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001: 序号从001-999

字体高度：20mm

字体颜色：黑色



Alle uangivne tolerancer: ±5 mm
Unspecified tolerances: ±5 mm

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SIEMENS		D1359929	